

Date: Monday, 6/5/2006 11:01:24 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CHAFING SHIELD	
Job Number	: 27414		Part Number	: D31891	
Estimate Number	: 10840		Drawing Number	: D3189 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/5/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/16/2006 Qty: 12	
Previous Run	: 27190		10 Unit. Each		
Written By	: <i>Signed</i> Comment Below				
Checked & Approved By	: <i>Signed</i> 06-06-06 N				
Comment	: Est. B 05-08-22 No longer made in-house KJ/JLM Est Rev:C 06-03-24 Rolling Now made in House JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET  
<b>Comment:</b> Qty.: 0.3360 sf(s)/Unit Total : 3.3600 sf(s) 304/316 SS .020" Sheet (M304S25GA) Batch: <u>M101000</u> <i>SAD 06-06-06 12</i>		
2.0	SHEAR	SHEAR  
<b>Comment:</b> SHEAR Cut to size as per Dwg D3189 <i>SAD 06-06-06 12</i>		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1  1-Deburr & Grind Rads as per Dwg D3189 <i>SAD 06-06-06 12</i> 2-Roll as per Dwg D3189 <i>SAD 06-06-14 12</i>		
4.0	QC5	INSPECT WORK TO CURRENT STEP  
<b>Comment:</b> INSPECT WORK TO CURRENT STEP  <i>26-06-14 12</i>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1  
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST134</u> <i>PCG/6/15 (12)</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

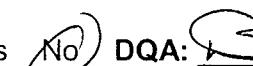
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

No DQA: 

Date: 06/06/16

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CHAFING SHIELD

Job Number: 27414

Part Number: D31891

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL  
Inspection Level 21

12  
16/06/06/16

Job Completion



16/06/06/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

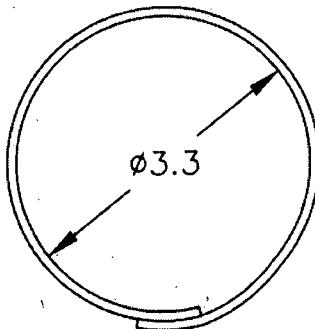
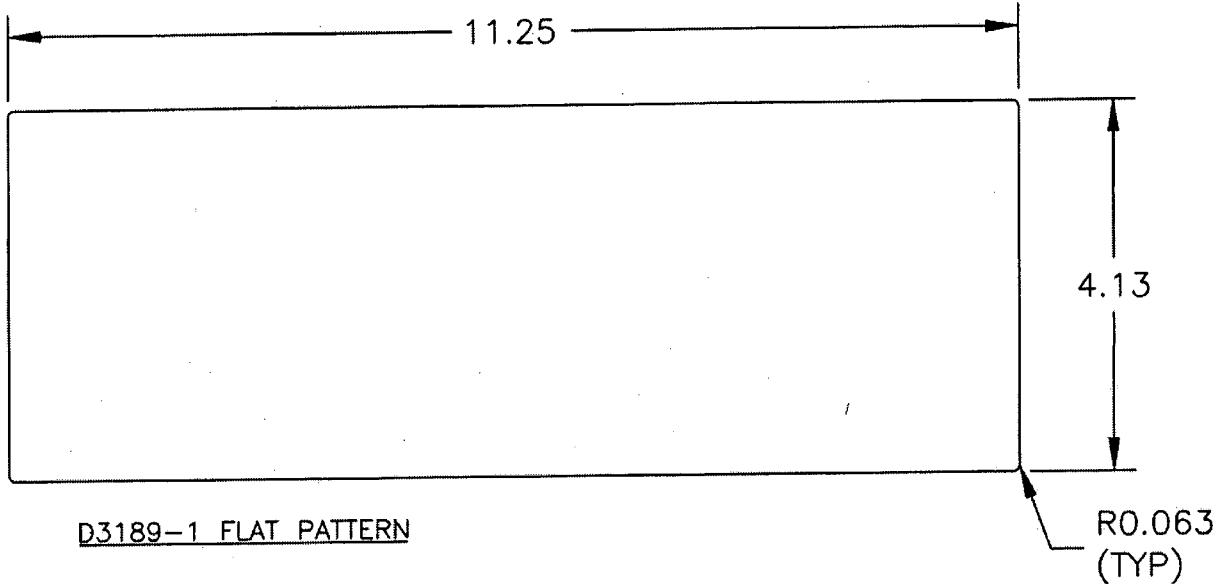
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

OF COPY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3189	SHEET 1 OF 1
DATE	TITLE	SCALE	1:2
03.05.08	CHAFING SHIELD		
A	03.05.08	NEW ISSUE	

**RELEASED**  
03.05.08 CP

D3189-1 ROLLING DETAIL  
NOT TO SCALE

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27414